Work Orde					Page 1						
tem ID: Revision ID:	D3023-1		,	Accept	*N900	040	100)* s	Setup Sta	1.71	S1*
Item Name:	Back Panel				•				St	^{op} *N	S2*
Start Date:	12/19/12	Start Qty: 1.00	*1*		Cust Item I	D:					· · · · · · · · · · · · · · · · · · ·
Required Date:	1/18/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:								_	· 04		
Approvals:	Process Pla	an: MLJ	Date: 12-12-19	Tooling:	Da	ite:		ŀ			R1*
•	QC:	, wie c	_	SPC (Y/N):	Da	nte:			St	^{op} *N	IR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr							-		
D3023	Rev	v A									
100				0.00							
100 Waterjet		FLOW WATER JET Memo		0.00					_0_		JM 13-2-4
FLOW CNC Waterj 2024, 03:		Dwg Rev: Prog Rev:		_							
		2-Deburr if	necessary								
110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00							
110		Memo		0.00					_0		JM 13-2-

Memo

Quality Control

												DQA:	Date	e:	
NCR:	Yes /	No				WORK ORDER NON-	COI	NFORN	MANCE / UP	DATE					*
												QA Closed:	Date	e:	
Work Orde	or:					DISPOSITION	٠			AGAINST	DE	PARTMENT	/PROCESS		
WOIR Old						Rework	7		Skid-tube	Crosstube	Γ]	Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab	⊢	Pro	d. Eng. Coor.	-	Quality
				****		Use-as-is	1		oforming	Finishing	—	4	re/Packaging		Other
NCR N	No					Work Order Update			Large Fab	Composite]	Supplier		
Root					Descri	otion of work order update		Initial	Ac	tion		Sign &		T	·
Cause		Date	Step	Qty	C	r Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data													·		
Equip/Tooling															
Operator							1								
Material	Ц														
Setup															٠
Other															
Process															
Supplier	Ш														
Training															
Unapproved				<u> </u>						•		<u> </u>			
							FAUL	LT CATE	GCIRY						
Landi	ng Gea				Г.	General	_	1			_	1 _ '	Г		
	—	ending			, -	Bend	\vdash	Grain			\vdash	Ovalized	<u> </u>		Pressure/Forced
	⊢⊣		ot Concer	ntric to O	^{7/5}	BOM/Route	\vdash	Hardwai			\vdash	Over/Under	⊢	\dashv	Temperature/Cure
		acks	5			Broken/Damaged	\vdash	4	on Incomplete	(1.1 · · · 1 · · · ·	\vdash	Part Incorre	<u>-</u>	-	Weld
	$oldsymbol{}$		Crimped.		-	Burrs	-	-1	ions Incomplete/	Unclear	-	Part Lost/M	- L	'	Wrong Stock Pulled
	⊢–	iffs			<u> </u>	Countamination	-	Mainte			-	Part Moved			
	—	eat Trea		Tulka	\vdash	Countersink	\vdash	Mislabe			-	Positioned V			
	-	-	Strip in	eauı	<u> </u>	Cut Too Short	\vdash	Misread			L	Power Loss/	ourge [_10	Other
	l (Kii	pples in	Rend		1	Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Orde Becember-19-12					*944	77*							Page 2
Item ID: Revision ID: Item Name:	D3023-1 Back Panel				Accept	*N900	040	100)*	Setup	Start Stop	10.	S1* S2*
Start Date: Required Date: Reference:	12/19/12 1/18/13	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Item I Customer:	ID:						
Approvals:		an:			_ 0 _		ate:			Run	Start Stop	[7]	R1* R2*
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC8- Inspect parts - seco	nd check		0.00 15	4			_1_				
130 *130* Brake NC Brake NC		Form as per dwg Memo			0.00								13/02
¹⁴⁰ *1∆∩* ^{QC}		QC5- Inspect part comple	eteness to step	on W/O	0.00 SW 13.2.5	5)			***	

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No	·			WORK ORDER NON-	COI	NFORM	AANCE / UPDAT				*
											QA Closed:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	4
Part I	- - No.				······································	Rework Scrap Use-as-is Work Order Update		Therm	Machining S noforming	rosstube imall Fab Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	П												
Material	П												
Setup	П							* .t.					
Other	П]				İ	7 a 1					
Process	П							196					
Supplier	П												
Training	П												
Unapproved	П												
						ļ.	AUI	LT CATE	GORY				
Landi	ng G	ear				General		_					_
		Bending				Bend		Grain	d.		Ovalized	L	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Uncle	ear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination]Mainte	nance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*944	177*						Page 3
Item ID: Revision ID: Item Name:	D3023-1 Back Panel			Accept	*N900	040 1	I	: Se	etup Start Stop	1/1	S1* S2*
Start Date: Required Date: Reference:	12/19/12 1/18/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Plan		Date:	Tooling: SPC (Y/N):		ate:		R	un Start Stop	1/	R1* R2*
Sequence ID/ Work Center II 180 *180* Packaging Packaging	D	Operation Description Identify as per dwg & Stock Memo	CLocation: W/T 00/	Set Up/ Run Hours 0.00	Tool ID		Code (Accept Oty	Reject Qty	Reject Number	Insp. Stamp
190 *190 QC		QC21- Final Inspection - W	√ork Order Release	0.00				[2	3/2/4)

Quality Control

MB-02-5

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	NANCE / UP	DATE			. *
											QA Closed:	Date:	
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
. WOIR OIG	=1					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.					Scrap		V	Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR f	No.					Use-as-is Work Order Update			Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cr	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													·
Operator			1										
Material													
Setup													
Other													·
Process													
Supplier	Ш							ļ					
Training	Ш												
Unapproved			<u> </u>							<u> </u>	1		<u></u>
						F	AUI	T CATE	GORY				
Landi	ng G	iear				General	_	-		_	_		-
	Ц	Bending				Bend	_	Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	O/S	BOM/Route	_	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
	\vdash	Crushed/	Crimped.			Burrs	L	Instructi	ions Incomplete	/Unclear	Part Lost/M	_	Wrong Stock Pulled
	Ш	Cuffs				Contamination	L	Mainte	nance		Part Moved		
		Heat Trea	at			Countersink		Mislabe			Positioned \		7
	Ш	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dirnensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-19-12 11:18:17 AM

Work Order ID:

94477

Parent Item:

D3023-1

Parent Item Name:

Back Panel

Start Date: 12/19/12

Required Date: 1/18/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.01.23Revised

PP Rev:D 08-04-16 now water jet DD verified by:E0

Compónent Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	370.1522	2.8777	3.0291579			
2024-T3 .032 sheet			,							<u> </u>		· · · · · · · · · · · · · · · · · · ·	<u>Jm13-2-</u>
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT022		370.1522							
•				1182	243	32.4962							
				118:	523	141							
				121	309	68.656							
				1230	096	27.6							
				123	574	100.4			123	3'5'] ' Y .			

											DQA	Date	2:	
NCR:	Yes	/ No			•	WORK ORDER NON-O	O	NFORM	ANCE / UPI	DATE			Ł	
		•							•		QA Closed	: Date	e: :	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMEN	/PROCESS	4	
Part I	٠ ، No	<u></u>				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining no forming Large Fab	Crosstube Small Fab Finishing Composite	-†	Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Act	ion	Sign &	,		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data									Í			1		
Equip/Tooling									İ					
Operator														
Material														
Setup							Ì							
Other														
Process														
Supplier														
Training														
Unapproved			1											
						F	AUL	LT CATE	GORY					
Landi	ng (Gear				General		_			_	_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure	e
	Г	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorr	ect	Weld	
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/N	Missing	Wrong Stock Pulle	ed
		Cuffs				Contamination		Mainte	nance		Part Move	<u>_</u>	_	
	Г	Heat Trea	nt		.	Countersink		Mislabe	led		Positioned	Wrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread	į		Power Loss	S/Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dirnensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

DART AEROSPACE LTD	Work Order:	94477
Description: Back Panel	Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0,132"	_		···U	Jkmoi
Ø0.191	+0.005/-0.001	0.193"	_		V	
1.660	+/-0.010	1.662"	-		υ	
0.375	+/-0.010	O.375°			V'	
1.340	+/-0.010	1.343	<u> </u>		V	
2.375	+/-0.010	2-336	-		V	
0.375	+/-0.010	0.376	_		√	
25.28	+/-0.030	25.28"	-		T	Jr muzo
27.03	+/-0.030	27.03'	_		T	
28.10	+/-0.030	28.10~	_		Τ	
1.30	+/-0.030	1.309"	_		v	
2.375	+/-0.010	2.379	-		✓	
8.711	+/-0.010	8.715	_		V	Podetos
5.597	+/-0.010	5.599			\$/	
8.57	+/-0.030	8.576"	_		V	
1.970	+/-0.010	1.972	-		✓	
7.42	+/-0.030	7.431	_		ν	
10.92	+/-0.030	10.921	-		V	
14.75	+/-0.030	14.75"	-		T	
·						

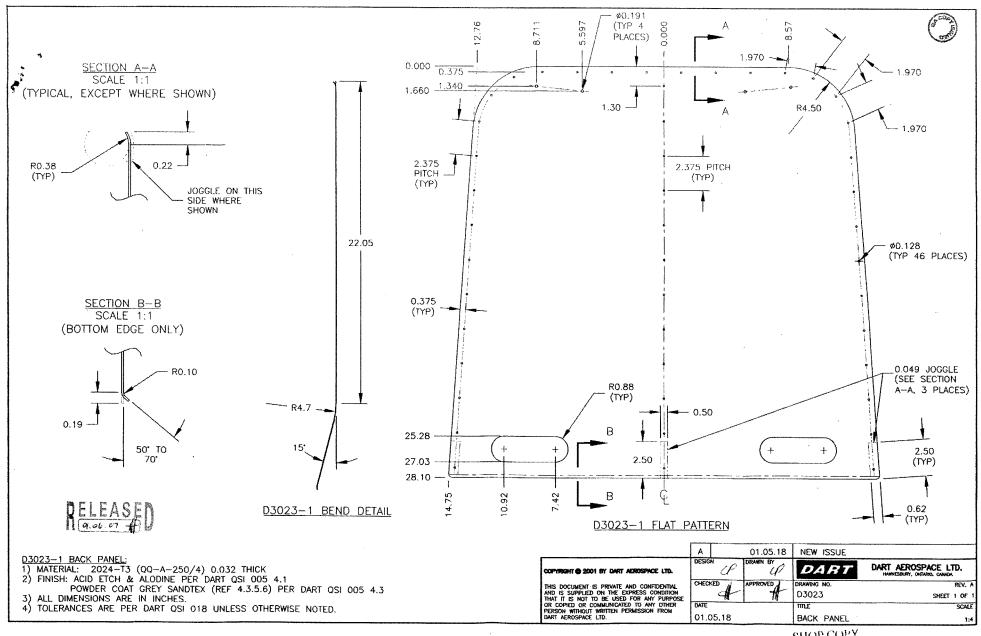
Measured by: Jm Audited by: 15 Prototype Approval: N/A

Date: 13-2-4

Date: 13-19

Date: N/A

Rev	Date	Change		Revised by	Approved
Α	08.11.27	New Issue	/	KJ/EC	. 3
				 77	V



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLL FD COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK OR DER

NO. SYY TR